

Date: Friday, 24/10/2008 10:34:18 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HOUSING WELDMENT	
Job Number	: 42918		Part Number	: D2207041	
Estimate Number	: 11874		Drawing Number	: D2207 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 24/10/2008 S.O. No. :		Drawing Revision	: C	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 15/11/2008 Qty: <i>10</i> Um: Each	
Previous Run	: 37604				
Written By	:				
Checked & Approved By	: <i>JUD 08-10-24</i>				
Comment	: Est. C 01.10.18 Added Step 10 and 11 SM Est D 07-10-11 REV C dwg		DD	verified by EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2208	Endcap, Torquemeter	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)	
		End Cap	
		Pick:	
	Qty Part Number Description Batch	<i>B 38144</i>	<i>22P</i>
	2 D2208 End cap		<i>8E 09/03/04</i>
2.0	D22071	Housing Body	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Housing	<i>11</i>
		Pick:	
	Qty Part Number Description Batch	<i>B 42939</i>	<i>11 P</i>
	1 D2207-1 Housing		<i>DE 09/03/04</i>
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Chamfer D2208 and D2207-1 before welding	<i>DE 09/03/04</i>
		2-Weld as per dwg D2207	<i>DE 09/03/04</i>
		3-Grind welds flush as per Dwg D2207	<i>AV 13 09-3-4 DE 09/03/04</i>
4.0	QC10	VISUAL INSPECTION OF GROUND WELDS	
		Comment: VISUAL INSPECTION OF GROUND WELDS	<i>PD 09-03-05</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCÉDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

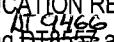
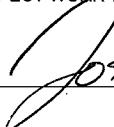
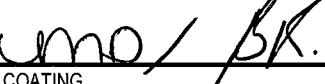
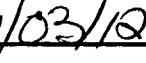
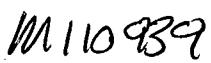
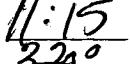
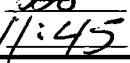
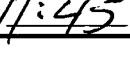
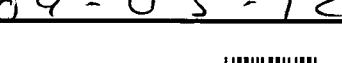
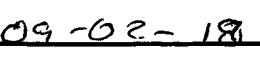
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 42918		Part Number: D2207041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC5 	INSPECT WORK TO CURRENT STEP  Sogloslab 
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1  FF 09-03-10 
Comment: INSPECT WORK TO CURRENT STEP 		
7.0	QC5 	INSPECT WORK TO CURRENT STEP  JOS03.10 
Comment: INSPECT WORK TO CURRENT STEP 		
8.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  XII 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1  09/03/12		
9.0	POWDER COATING 	POWDER COATING  XII 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  M10939 		
START TIME: 11:15  OVEN TEMPERATURE: 320°  FINISH TIME: 11:45  11 09-03-12		
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  XII 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 09-03-12 		
11.0	ALS71032130 	Insert  XII 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s) Insert Qty Part Number Description Batch 4 ALS7-1032-130 Insert M108606  SEE QSI 017 09-02-18 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

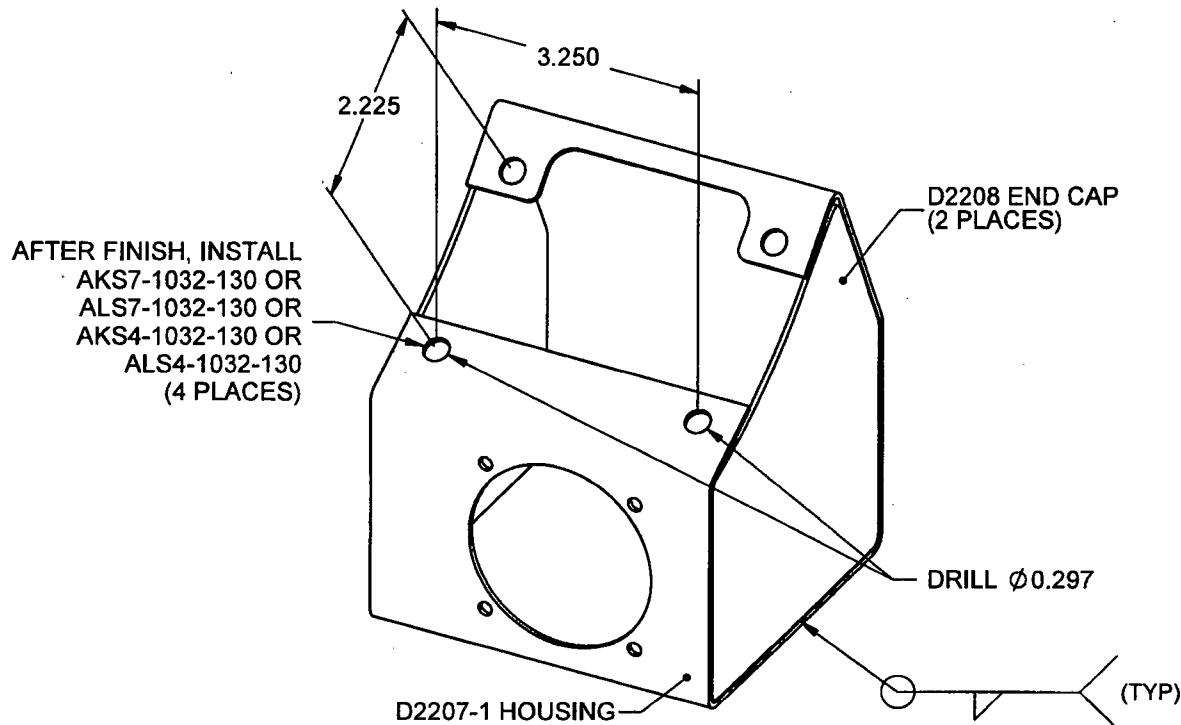
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



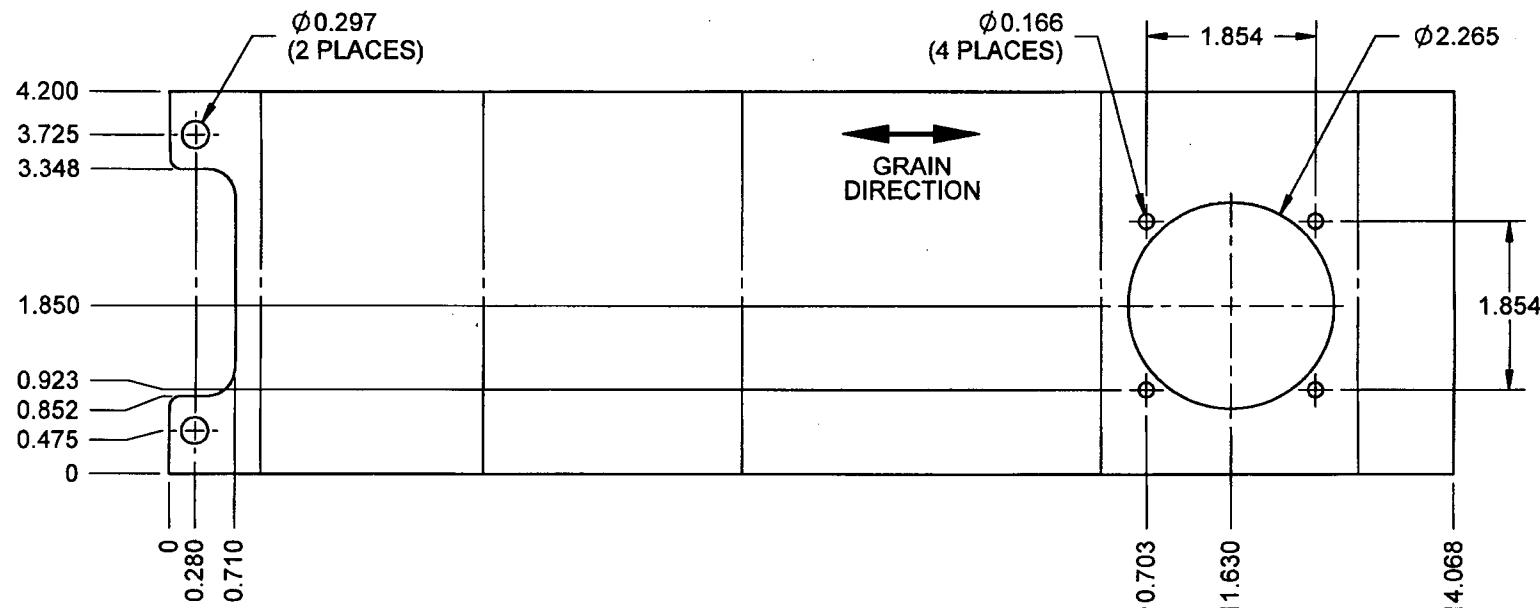
D2207-041 HOUSING ASSEMBLY

NO 472018
WELD
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
NOTICE
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

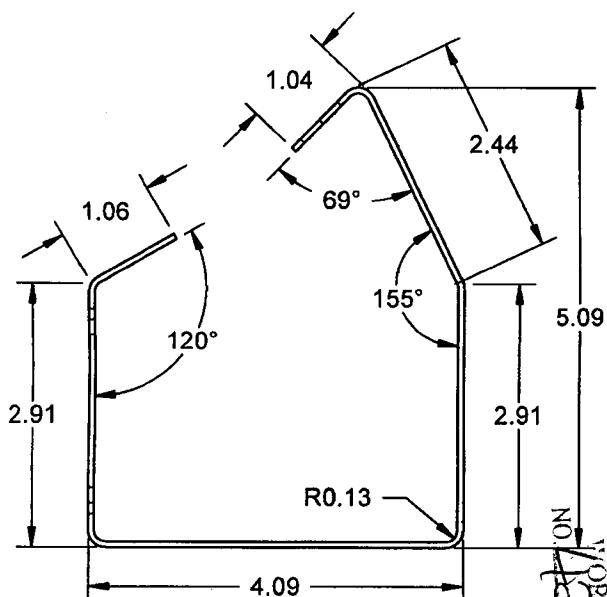
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION		
DESIGN	7F	DART AEROSPACE LTD	
DRAWN	7B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	E	D2207	SHEET 1 OF 2
APPROVED	7F	TITLE	SCALE
DE APPR.	7F	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



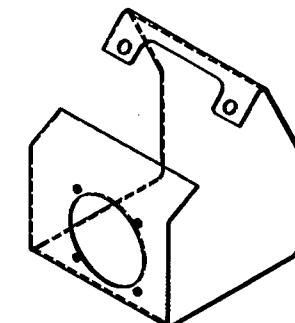
D2207-1 BENDING DETAIL

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
07.08.29

SHOP COPY
RETURN TO
ENGINEERING

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JP	
CHECKED	PH	DRAWING NO.
MFG. APPR.	E	D2207
APPROVED	PH	REV. C
DE APPR.	PH	SHEET 2 OF 2
DATE	07.06.28	SCALE
		1:2
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ISOMETRIC VIEW
(SCALE 1 : 4)